

**Work Order ID 70040**

Page 1

Wednesday, May 25, 2011 1:03:49 PM

Item ID: D3371-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Lock Base

Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: CLDate: 11/05/25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3371

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.00" x 2.25" x 7.370" long

cut 11/05/304 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine D3371-1 as per Folio FA486 and Dwg D3371 □ Debur □ Finish 8-32  
thread by hand □ Identify as D3371-1B.A 11/05/304 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 11/05/314 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 70040**

Page 2

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Item Name: Pedal Lock Base

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00

and 11/05/31

4

0



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

4

0

0

11/06/01



HandFinish

Memo

0.00

Hand Finishing

145

Fire Red(Ref:4.3.5.10) per QSI005 4.3

0.00

4x

0

0

11/06/02



Powdercoat

Memo

0.00

Powder Coating

POWDER COAT:

Start Time:

Oven Temperature:

Finish Time:

11:20  
320 OF  
11:50

11102391

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 70040**

Page 3

Wednesday, May 25, 2011 1:03:49 PM

Item ID: D3371-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Lock Base

Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC3- Inspect Part Finish 0.00



QC Memo 0.00

Quality Control

40 BR 11-6-2

160 Identify as per dwg &amp; Stock Location:

0.00



Packaging Memo 0.00

Packaging

83 116662



170 QC21- Final Inspection - Work Order Release 0.00



QC Memo 0.00

Quality Control

11/6/3

ME

11-06-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 25, 2011 1:03:46 PM

Page 1

Work Order ID: 70040



Parent Item: D3371-1



Parent Item Name: Pedal Lock Base

Start Date: 5/25/2011

Required Date: 6/10/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A□05.01.18□New issue□KJ/JLM□IPP RevB: add powdercoat DD  
10.01.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.25 0		Purchased	No			100	f	0.0000	0.625	2.631579			
6061-T6 Bar 2.00 x 2.25													

2.00X3.500 Batch M112764 ink 11/05/30

2.632"

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	70040
<b>Description:</b> Pedal Lock Base		<b>Part Number:</b>	D3371-1
<b>Inspection Dwg:</b> D3371	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
60°	+/-0.5°	60°	✓		Angle meter	CNC-03
2.25	+/-0.030	2.248	✓		Vern	GA-01
1.650	+/-0.010	1.649	✓		"	"
1.648	+/-0.010	1.647	✓		"	"
0.700	+/-0.010	0.701	✓		D-6	GA-08
3.955	+/-0.010	3.955	✓		Vern	GA-01
0.600	+/-0.010	0.599	✓		"	"
0.104	+/-0.010	0.107	✓		"	"
0.305	+/-0.010	0.314	✓		"	"
45°	+/-0.5°	45°	✓		Angle meter	CNC-03
0.672	+/-0.010	0.670	✓		Vern	GA-01
Ø1.300	+/-0.010	Ø1.300	✓		"	"
1.450	+/-0.005	1.450	✓		"	"
7°	+/-0.5°	7°	✓		Angle meter	CNC-03
2.00	+/-0.030	2.000	✓		Vern	GA-01
1.125	+/-0.010	1.127	✓		"	"
Ø1.125	+/-0.010	Ø1.125	✓		R-6	ref.
R0.500	+/-0.010	R0.500	✓		Vern	GA-01
1.000	+/-0.010	1.000	✓		Vern	GA-01
0.375	+/-0.010	0.373	✓		"	"
Ø0.203	+0.005/-0.000	Ø0.204	✓		"	"
7.19	+/-0.030	7.185	✓		Vern	CNC-02
4.500	+/-0.010	4.498	✓		Vern	GA-01
0.500	+/-0.010	0.498	✓		"	"

<b>Measured by:</b> J.A.	<b>Audited by:</b> <i>mk</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11/05/31	<b>Date:</b> 11/05/31	<b>Date:</b>	N/A

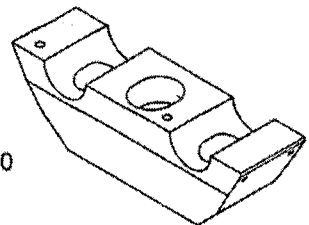
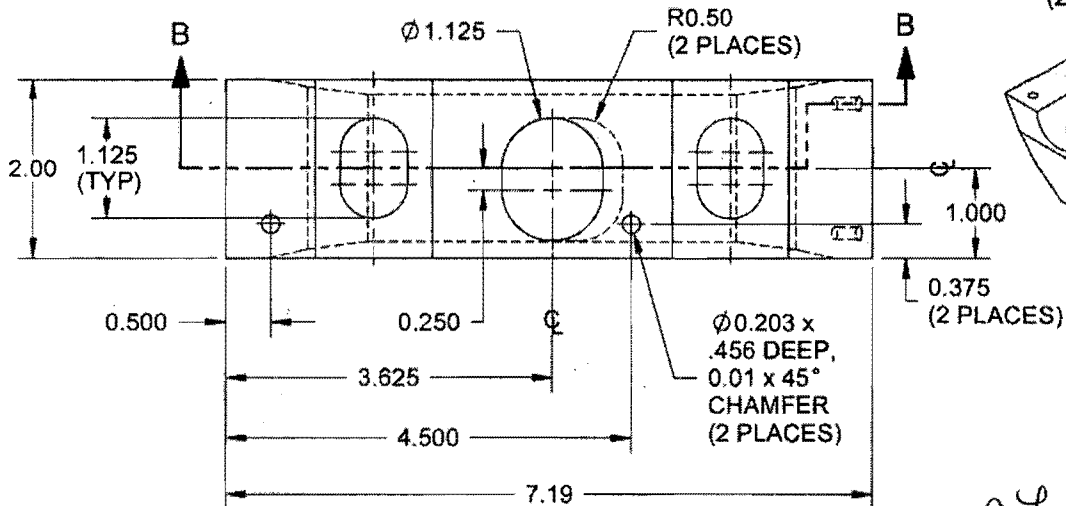
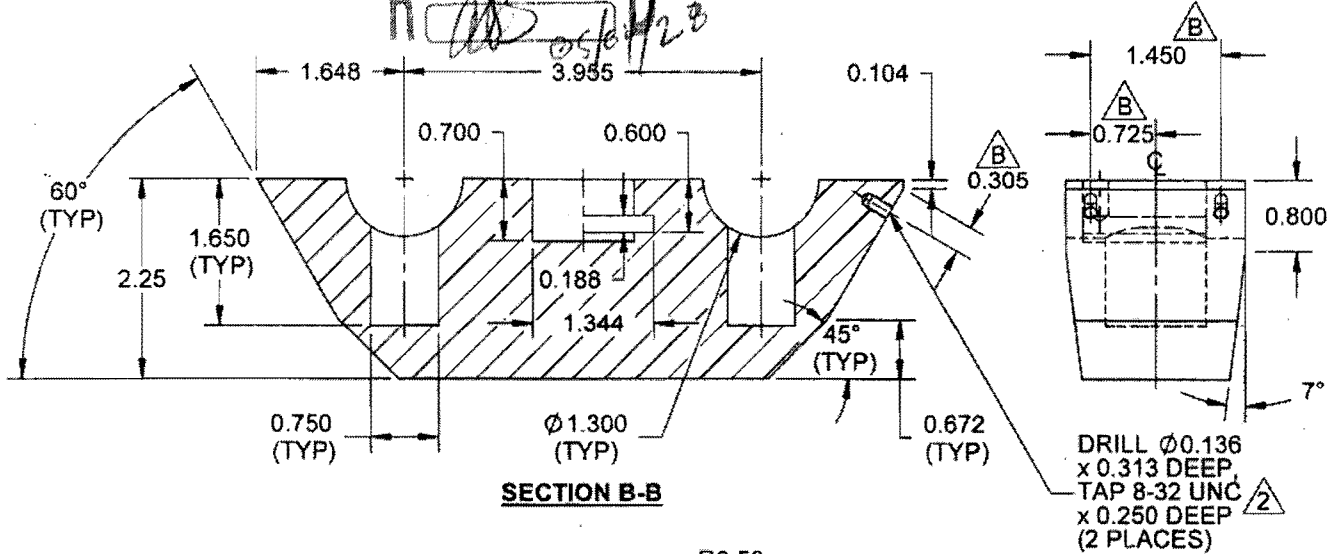
Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Revised dimensions	KJ/JLM	<i>[Signature]</i>





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3371</b>	REV: B SHEET 2 OF 4
DATE <b>05.03.22</b>		TITLE <b>PEDAL LOCK</b>	SCALE 1:2

**RELEASED**  
*[Signature]* 05/04/22



*CL11105125*  
*W10: 76640*

**D3371-1 BASE**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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